

Work Order ID 103262

Thursday, June 20, 2013 11:02:04 AM

103262

ASAP

Page 1

Item ID: D3695-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Slider Assembly ***4***
 Start Date: 6/20/2013 Start Qty: 4.00 Cust Item ID:
 Required Date: 6/25/2013 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: *mf* Date: *13-6-20* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3695	Rev E								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- install heli-coil as per dwg D3695 2- install D3695-3 and spring plug as per dwg D3695								
110		0.00							
110	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	Identify as per dwg & Stock Location: <i>8T247</i>								
Packaging	Memo	0.00							
Packaging									

FF
13-06-27
PTO
3
3x
13-6-28

DQA:

Date:

QA Closed:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>103262</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3695-041</u>	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	
NCR No. <u>13-2993</u>	Scrap <input checked="" type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input checked="" type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	13-6-28	100	1	found at inspection that had acceptable was not operable well due for stopper	DAS 16 2-83	part scrap and destroyed	FF 13-06-28	13 6 28	DAS 16 2-83
Doc/Data					052042				
Equip/Tooling					13/6/28				
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

RC INSPECTION

FAULT CATEGORY

Landing Gear		General		Outside Dimensions		Pressure/Forced	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure	<input type="checkbox"/> Weld
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Other
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Part Moved		
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved		<input type="checkbox"/> Positioned Wrong		
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong		<input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge				
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread					
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set					
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration					
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence					

QC was machine manually +
 missed it inspection on
 w/o 96593 D3595-3

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Item ID: D3695-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Slider Assembly

Stop ***NS2***

Start Date: 6/20/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/25/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

13/7/24
ALB0628

Picklist Print

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Work Order ID: 103262
Parent Item: D3695-041
Parent Item Name: Slider Assembly

Start Date: 6/20/2013 Required Date: 6/25/2013
Start Qty: 4.00 Required Qty: 4.00

Comments: IPP Rev:A new issue 08-03-27 DD verified by:ec
IPP Rev:B 09-01-13 revC as per dwg DD verified by:ec
revD DD verf:JLM IPP rev:C 10.11.29 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3695-1 Slider		Manufactured	No			100	Each	5.0000	1	4		FF 13-06-27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST247		5							
				89848		1							
				96563		4				34			
D3695-3 Stopper		Manufactured	No			100	Each	4.0000	1	4		FF 13-06-27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST062		4							
				96539		4				4			
D3801-1 HAND RETRACTABLE SPRING PLUNGER		Manufactured	No			100	Each	23.0000	1	4		FF 13-06-27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA	75178	20				34			
				100407		20							
				ST066		3							
				99271		3							
MS21209-F120 HELI COIL		Purchased	No			100	Each	60.0000	4	16		FF 13-06-27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST320		60							
				114037		18							
				121709		42				16			
MS21209-F625 Heli-Coil		Purchased	No			100	Each	61.0000	1	4		FF 13-06-27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST319		61							
				108138		61				4			

Picklist Print

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Work Order ID: 103262

Parent Item: D3695-041

Parent Item Name: Slider Assembly

Start Date: 6/20/2013

Required Date: 6/25/2013

Start Qty: 4.00

Required Qty: 4.00

MS24693-C276

Purchased

No

100

Each

90.0000

4

16

Screw

FF 13-06-27

Location

Loc Qty

Loc Code

ST300

90

113845

90

12 ~~16~~

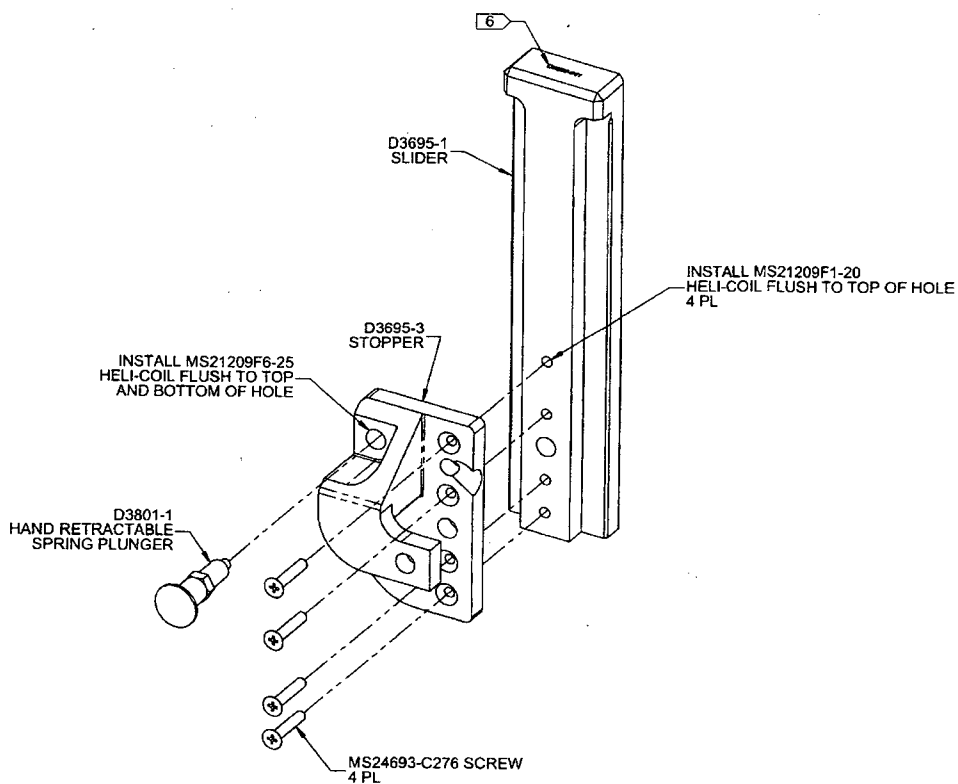
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Shop Packet Print

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8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D3695-041	SLIDER ASSEMBLY
1	1	D3695-1	SLIDER
2	1	D3695-3	STOPPER
3	1	D3801-1	HAND RETRACTABLE SPRING PLUNGER
4	4	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
5	1	MS21209F6-25	HELI-COIL, SCREW LOCKING (RED)
6	4	MS24693-C276	SCREW



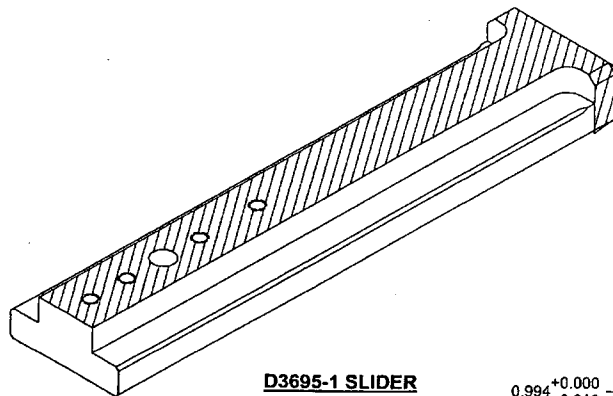
D3695-041 SLIDER ASSEMBLY

- D3695-041 NOTES:**
1) MATERIAL: NONE
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENT P/N "D3695-041" PER QSI 044 6.1
7) WEIGHT: D3695-041 = 0.63 lbs

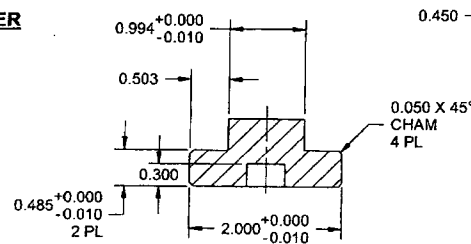
103262

RELEASED
2012-07-16

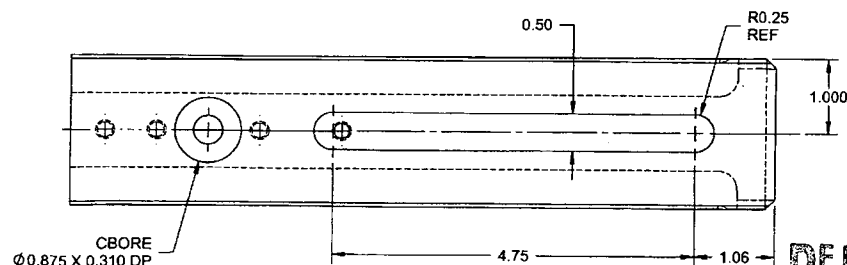
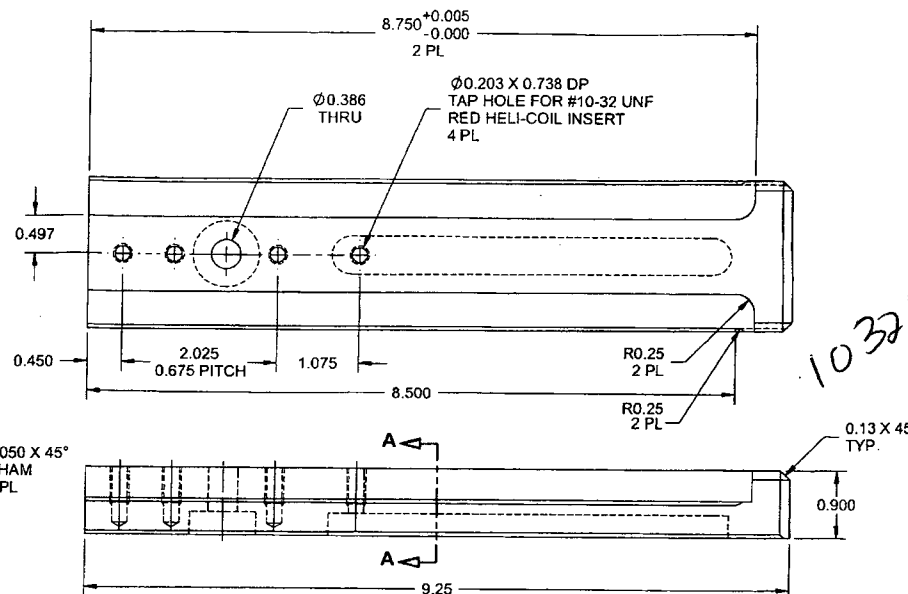
E	ADDED R0.93 (ZN C8-3). REASON: PAR12-177.	MB	12.06.27
D	NOTE 6 UPDATED PER OSI. DIM 0.994 ^{+0.000} / _{-0.015} WAS 1.000 ^{+0.000} / _{-0.015} & 0.503 WAS 0.500 (ZN C6-2). REF NCR 10-324. CHAMFER ADDED TO D3695-1 (ZN C5-2)	JPH	10.09.24
C	UPDATED BOM TO CURRENT STANDARDS; REVISED ITEM 12 (ZN D3-1): DIMS 1.83 AND 1.075 ^{+0.000} / _{-0.000} WERE 1.81 AND 1.063 ^{+0.000} / _{-0.000} (ZN B8-3 AND C4-3). REASON: COMPENSATE FOR PAINT THICKNESS AND ELIMINATE RATTLE UPON ASSEMBLY.	MB	08.11.04
B	P/N D3808-1 WAS WIP-510 (ZN C7-1 AND D3-1). REASON: PURCHASED PARTS NOW PROCURED THROUGH D3801 SPEC CONTROL DRAWING	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.06.27		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3695		REV. E	
TITLE SLIDER ASSEMBLY		SHEET 1 OF 3	
DATE 12.06.27		SCALE NTS	
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D3695-1 SLIDER



SECTION A-A



D3695-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3 - MASK ALL HOLES AND UNHATCHED AREAS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.43lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3695	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SLIDER ASSEMBLY	NTS
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